Date:

Tuesday, 23/12/2008 1:22:40 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPAD

Job Number **Estimate Number** : 44294 : 10313

P.O. Number

: 23/12/2008 This Issue Prsht Rev.

: NC

: 11 : 43989

: SMALL /MED FAB Type

Part Number

: D26483

Drawing Number

: D2648 REV D

Project Number Drawing Revision

: N/A : D

Material

Due Date

: 20/01/2009

Qty:

40 Um: Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment : Est: E 02.09.18

Re-format; Incorporated D2648-1 KJ/RF

Now on Waterjet 06-08-14 Est Rev:F

S.O. No. :

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0788 sf(s)/Unit

Total: 3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 105706

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev: D

Prog Rev: D

B9-1-6



2-Deburr if necessary

3.0 QC2



13 9-1-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE



SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessar



Page 1

3

Form: rprocess

Duit Ac	Обрасс	Liu								
W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										į
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A :	Date: _	
				Disposition: QA			A: N/C Closed: Date:			
NCR:		\	WORK OR	DER NON-CONFO	RMANCE	(NCR	R) .			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	cation	Approvai	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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7										
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Date: Tuesday, 23/12/2008 1:22:41 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 44294 Part Number: D26483 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FAB 1 7.0 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R560Hardcoat 19109479 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 Comment: VISUAL INSPECTION OF GROUND WELDS 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 POWDER COATING POWDER COATING m/09648 **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: 6/26OVEN TEMPERATURE: 320° FINISH TIME: 11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPEC XUU POWDER COAT/CHEMICAL CONVERSION 09-01 12.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Location:_

Form: rprocess

Page 2

Dart Aerospace Li

W/O:			WC	RK ORDER CHANGI	ES				·	
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\ :	Date: _		
	Reso	olution:	Disposition: QA: N/C Clo				losed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section E			Verific		Approval	Approval	
	Sec	Section A	Chief Eng	Action Description Chief Eng	Sign & Section C	on C	Chief Eng	QC Inspector		
							· la-			

Date: Úser:

Tuesday, 23/12/2008 1:22:41 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44294

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





W/O: WORK ORDER CHANGES					· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<u> </u>	<u> </u>					
		:						
Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DC	A:	Date: _	
	Resolutio	n:	Disposition:	QA: N/C	Closed: _		Date: _	
			WORK OPDED NON CON	IEODMANCE (N	CD/			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B		Verification	Annuaral	Annual	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				· · · · · · · · · · · · · · · · · · ·				

DART AEROSPACE LTD		Work Order:	44294
	40		7
Description: WEAR PA	D	Part Number:	D2698-3
			2
Inspection Dwg: DJ648-3, R	ev: D	 	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	TY Broke	·
X First Article	X Proto	ype

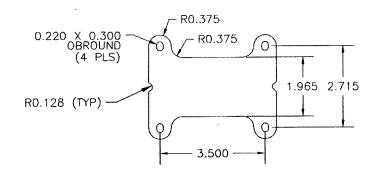
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
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2.715	4010	2718	مد			
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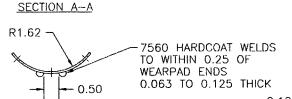
Measured by: R	Audited by:	Prototype Approval:	·
Date: 9-1-6	Date: 09/61/66	Date:	4

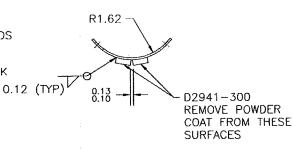
Rev	Date	Change	Revised by Approved
Α		New Issue	KJ/JLM



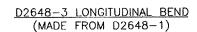
D2648-1 FLAT PATTERN

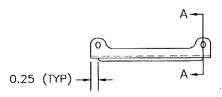


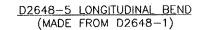


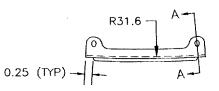


SECTION B-B

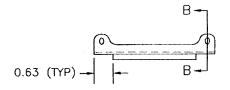








D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



Morning of the





BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010—1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7							
С	97.06.26	R31.6 WAS R19.6							
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250							
Α	97.03.25	NEW ISSUE							
DESIGN 升	DRAWN BY	DART DART AEROSPACE USA, INC.							
CHECKE	APPROVED	DRAWING NO. REV. D							
# #		D2648 SHEET 1 OF 1							
DATE	······································	TITLE SCALE							
99.11	.17	WEARPAD 1:2							

Dart Aerospac	e l	Ltd
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W/O:			: V	ORK ORDER CHANC	GES		·				
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
•											
10,24				x		į				,	
Part No	:	PAR #:	Fault Category: No			CR: Yes No DQA: Date:					
	Re	solution:				A: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification			Approval Appr	Approvai	
	SIEF		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
	;										